



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2966-1-BENT
Job Sheet 213394



Part No: D2966-1-BENT

Job Qty: 4 pcs

Part Name: Skidtube Assembly 105



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/25/20

Job Tracking No:

Due Date: 10/5/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP rev A 10.09.17 New issue EC verified by:DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S303845



Part: D2966-1-BENT

Job No: 213394

Serial No/Batch: S303845

Revision:

Inspector:

Exp Date:

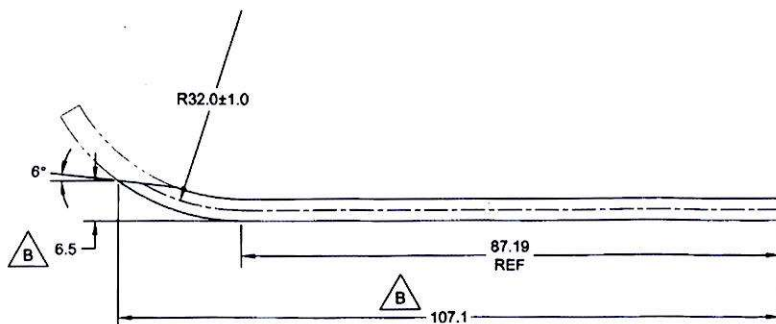
Instructions: Various STC's

Date: 09/29/20

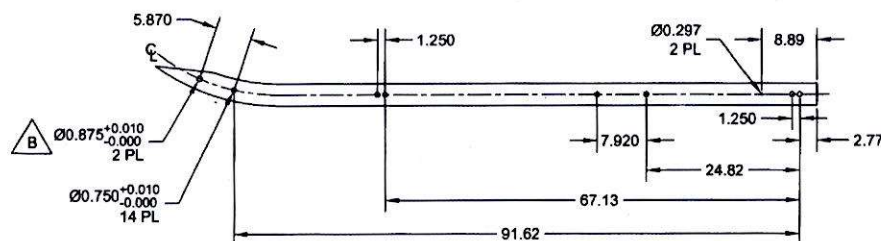
Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Skidtubes - Bend - 1	4 pcs		10/5/20	0.00	2.88	Skidtubes - Bend		
150	QC 5	4 pcs		10/5/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE SEP 30 2020
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
300	Packaging 3-1 - Stock - B4B	4 pcs		10/5/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		BE SEP 30 2020
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		
							Packaging 3 - 37 - B4B		
310	QC 21 - SA	4 pcs		10/5/20	0.00	0.00	QC 21 - SA - 21		
							QC 21 - SA - 70		DAS SEP 30 2020
							QC 21 - SA - 9		21
							QC 21 - SA - 77		9-89
							QC 21 - SA - 28		
Part Op 120 - (CNC Delta 100 Bender) 1-Bend tube as per program BO105 on CNC Bender and Dwg D2966. Bend folio #1 use Descriptions: bending aid DT9631 2-Cut Fwd end of the tube using DT8185-1 150 - QC5- Inspect part completeness to step on W/O 300 - Identify as per dwg & Stock Location: LG002 310 - QC21- Final Inspection - Work Order Release									
Job BOM									
Part / Item	Component Name	Quantity	Operation	Container					
D2962-150	3.540 Outer Tube, Extrut	4 pcs (1 ea)	120-Skidtubes - Bend - 1	52104503					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Skidtubes - Bend - 1	D2962-150	4	54	0
Part Specifications				
Specifications could not be found.				

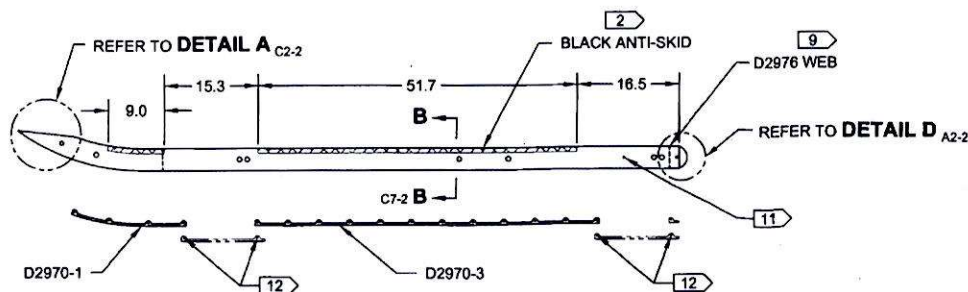
Plex 9/25/20 7:18 AM Dart.lajeunesse.marie



D2966-1 BENDING/CUTTING DETAIL
(MAKE FROM D2962-125 EXTRUSION)



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL

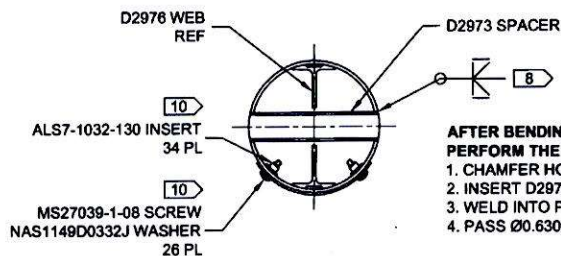
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 213394 M15
2009-25

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D2966-041	SKIDTUBE ASSEMBLY
1	1	D2966-1	TUBE
2	1	D2964	CAP
3	1	D2965	CAP
4	1	D2970-1	WEARPLATE
5	1	D2970-3	WEARPLATE
6	1	D2971	CROSS BOLT SPACER
7	7	D2973	CROSS BOLT SPACER
8	1	D2976	WEB
9	1	D3176-1	BUSHING
10	1	D3176-3	NUT
11	36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
12	28	MS27039-1-08	SCREW
13	2	MS27039-1-09	SCREW
14	28	NAS1149D0332J	WASHER

NOTES:

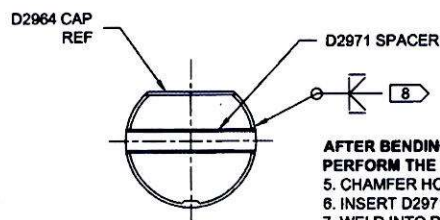
- 1) MATERIAL: MAKE D2966-1 FROM D2962-125 EXTRUSION (INITIAL LENGTH = 125.0)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB.
STANDARD: PRIME (REF. 4.2.1.3.2) AND PAINT MATTE BLACK PER DART QSI 005 4.2
OPTIONAL: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
OPTIONAL: BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE
CENTER-LINE PER DART 005 4.4.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS STATED OTHERWISE
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 18 lb
- 8) WELDING: PER DART QSI 004
- 9) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 10) INSTALL ALS7-1032-130 AFTER FINISH PER SECTION B-B (34 PLACES). DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 11) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND NAS1149D0332J WASHER IN 2 PLACES THIS LOCATION BEFORE PRIME AND PAINT (OR POWDER COATING).
- 12) DO NOT INSTALL MS27039-1-08 SCREWS AND NAS1149D0332J WASHERS IN THESE LOCATIONS.

B	UPDATE TO CURRENT STD; INCORP. REV. A1 AND A2: CHG COLOR TO BLACK SANDTEX (ZN C3-1) AND ADD D3176-1/-3 (ZN D3-1, C1-2). PRIME AND PAINT NOW. STD WHILE POWDER COAT IS OPTIONAL (ZN C3-1); Ø0.875 WAS Ø0.750 (ZN B52-), Ø0.750 WAS Ø0.630 (ZN B6-2); TOL CHG (ZN D8-1 AND D6-1).	MB	13.12.02
A	NEW ISSUE	RF	00.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.12.02		
DART AEROSPACE USA, INC KENT, WA DRAWING NO. D2966 TITLE BO 105 SKIDTUBE ASSEMBLY SCALE NTS COPYRIGHT © 2000 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



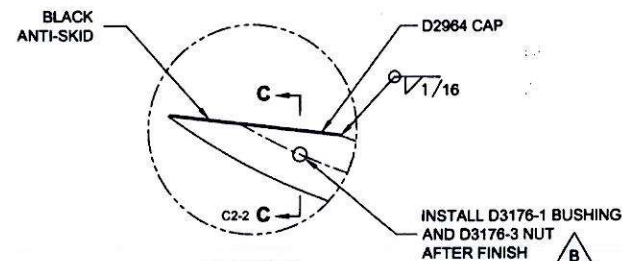
**AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:**
 1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D2973 SPACER, 7 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.630 DRILL TO REMOVE SPILL OVER

SECTION B-B A8-1
SCALE 6X

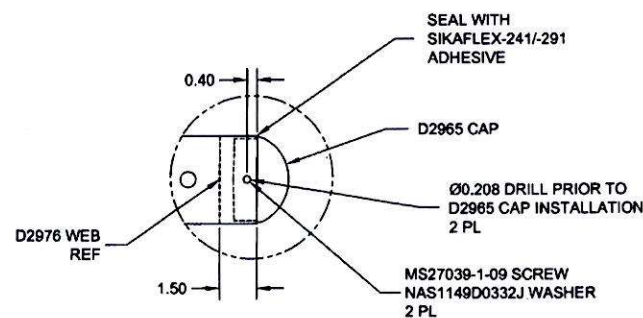


**AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.875 HOLES ONLY:**
 5. CHAMFER HOLE 0.030 x 45°
 6. INSERT D2971 SPACER
 7. WELD INTO PLACE AND GRIND FLUSH
 8. PASS Ø0.750 DRILL TO REMOVE SPILL OVER

SECTION C-C C2-2
SCALE 6X



DETAIL A B7-1
SCALE 6X



DETAIL D A4-1
SCALE 4X

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2966	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BO 105 SKIDTUBE ASSEMBLY	NTS
DATE	13.12.02	COPYRIGHT © 2000 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
 2014-02-03

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					